

Work Order ID 61879

Wednesday, September 08, 2010 3:08:30 PM



Page 1

Item ID:	D4164-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Nut Plate Adapter Assembly					
Start Date:	9/8/2010	Start Qty:	100.00		Cust Item ID:	
Required Date:	9/13/2010	Req'd Qty:	100.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10/9/05	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4164	A								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D								
6061 .040	Dwg Rev:								
	Prog Rev:								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

1310-9-15

110

1310-9-15

counters



7/10




Work Order ID 61879

Wednesday, September 08, 2010 3:08:30 PM

Page 2

Item ID:	D4164-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Nut Plate Adapter Assembly				Stop	
Start Date:	9/8/2010	Start Qty:	100.00		Cust Item ID:	
Required Date:	9/13/2010	Req'd Qty:	100.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- Deburr 2-C'sink as per Dwg								
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
141  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

EP 10/09/21 (110)

8/10/09/21

(contd)
(110)

=> 10/09/21

110 *g*

Work Order ID 61879

Wednesday, September 08, 2010 3:08:30 PM



Page 3

Item ID: D4164-041

Accept



Setup Start



Revision ID:

Item Name: Nut Plate Adapter Assembly

Stop



Start Date: 9/8/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

DR 10-9-21



QC

Memo

0.00

Quality Control

110

φ

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Nut plate as per Dwg

9/10/09 27 110

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/09/27

count
x110

Work Order ID 61879

Page 4

Wednesday, September 08, 2010 3:08:30 PM

Item ID: D4164-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Adapter Assembly

Start Date: 9/8/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 225

0.00



Packaging

Memo

0.00

Packaging

10/09/27 (110)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/27
CY1019127

Picklist Print

Wednesday, September 08, 2010 3:08:34 PM

Page 1

Work Order ID: 61879

Parent Item: D4164-041

Parent Item Name: Nut Plate Adapter Assembly

Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP REV:A NEW ISSUE 10-09-07 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

100

sf

86.7300

0.001

0.105263

1.5



1810-9015

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT21

86.73

113004

86.73

Each

37.0000

1

100

MS21059L3

Purchased

No



Nut Plate

Location

Loc Qty

Loc Code

ST301

37

114718

37

Each

5,021.000

2

200

MS20426AD3-3

Purchased

No



Rivet

Location

Loc Qty

Loc Code

ST316

5021

19099

4774

7681

247

113004

9/5/10/09/27

M115727 (2W)

M115708 (834)

M114718 (60)

9/5/10/09/27

87 197

4723

119099

DART AEROSPACE LTD	Work Order:	
Description: NUT PLATE ADAPTER ASSEMBLY	Part Number:	D4164-041
Inspection Dwg: D4164-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

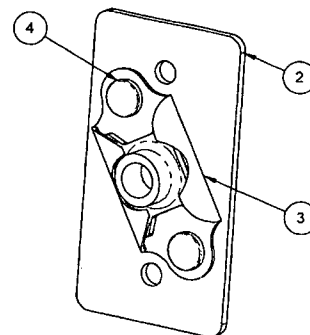
Prototype

[illegible]

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-19	Date:	12/09/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4164-041	NUT PLATE ADAPTER ASSEMBLY
2	1	D4164-1	NUT PLATE ADAPTER
3	1	MS21059L3	NUT PLATE
4	2	MS20428AD3-3	RIVET



D4164-041 NUT PLATE ADAPTER ASSY

NOTES:

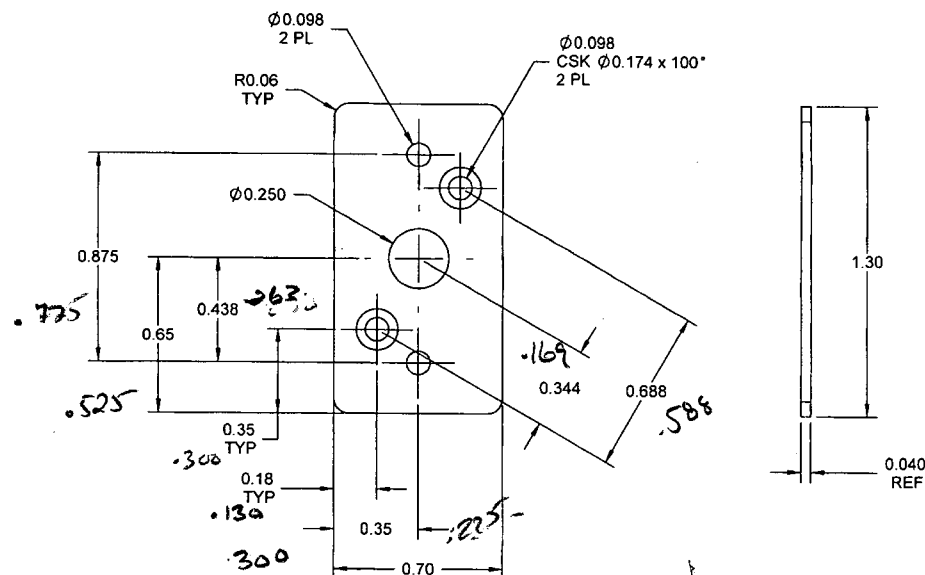
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4164-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.006 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. U1879

BS10-9-08

RELEASED
2010-09-07
MP

A	NEW ISSUE	RF	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	KB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	D4164	SHEET 1 OF 2
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	NUT PLATE ADAPTER ASSY	NTS
DATE	10.07.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4164-1 NUT PLATE ADAPTER

NOTES:

- 1) MATERIAL: 6061T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
PER DART SPEC. M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.003 lbs

DESIGN	KB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4164	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	NUT PLATE ADAPTER ASSY	NTS
DATE	10.07.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2010-09-07
JAP

